



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3717
Job Sheet 170472



7

Part No: 646.3717

Job Qty: 12 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/8/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A SHEET 8 IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		2/7/18	0.00	0.00	Start Up Waterjet		SC 18/02/04
110	Waterjet	12 pcs		2/8/18	0.00	0.33	Waterjet1		SC 18/02/04
120	QC	12 pcs		2/8/18	0.00	0.00	QC2 Waterjet-1		SC 18/02/04
130	QC	12 pcs		2/8/18	0.00	0.00	QC8-1		SC 18/02/04
140	Outsource	12 pcs		2/8/18			ATG001-VC	Outsource 4	AT 18/03/01
150	Packaging	12 pcs		2/8/18	0.00	0.00	Packaging2		AT 18/03/01
160	QC	12 pcs		2/8/18	0.00	0.00	QC5		AT 18/03/01
190	Packaging	12 pcs		2/8/18	0.00	0.00	Packaging3-1	CK 105	AT 18/03/01
200	QC21-SA	12 Ea		2/8/18	0.00	0.00	QC21		AT 18/03/01

Part Op 110 - 1-Cut as per Dwg

Descriptions: 140 - Issue P/O ATG, black anodize and prime as per dwg 646.3717 Rev. A

190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

D10 038962

DAS 13 FEB 07 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.063	0	209	0	0
	5018007	0.5			

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	3.500Inches ± 0.030	3.530 3.470	3,500	
2	Doubler	1.500Inches ± 0.030	1.530 1.470	1,501	
3	Doubler	0.063Inches ± 0.010	0.073 0.053	0,062	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

DISPOSITION

AGAINST DEPARTMENT/PROCESS

Work Order: _____

Part No. _____

Tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
ining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
ining	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Fab	☐	Composite	☐	Supplier	☐		

Effective : _____

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

Change No:
Operation:
Revision:
Original Serial #:

Start up Operation
646.3717
S038801



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

FAULT CATEGORY

Equip/Tooling	☐	Offset/Setup	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Handling/Pre	☐	Supplier	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Material	☐	Training	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Internal Transport	☐	Use for Testing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Tribal Knowledge	☐	Poor Information	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
LOA	☐	Rushing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Substation	☐	Product Improvement	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Past Expiry Date	☐	Process Improvement	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
Misidentified	☐	Manufacturing Process	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
		Past Due	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
OTHER : _____											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038962

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038962

PO Date: 2/6/18

Due Date: 2/14/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
FEB 12 2018

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170205	RBW6705G02631-3G-1	Lever Rigging Fork, T/R Actuator CLEAR ANODIZE (RED BARN) -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant - Certificate of Conformity is required	Firmed	2/16/18	2 pcs 8x	0 pcs 7x	2 pcs AT 18/02/18	\$9.38/pcs	\$18.76
2	170188	RBW6705G02431-3G-1	Lever Rigging Fork -Issue P/O to ATG: - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	2/16/18	7 pcs ✓	0 pcs 7x	7 pcs AT 17/02/18	\$9.38/pcs	\$65.66
3	170797	RB T103311-101	Sleeve Tool -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	2/16/18	6 pcs ✓	0 pcs 6x	6 pcs AT 18/02/18	\$9.38/pcs	\$56.28
4	170590	RBE350A94-5201-20	Cartridge, Dummy, Fuel -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/16/18	6 pcs ✓	0 pcs 6x	6 pcs AT 18/02/18	\$13.55/pcs	\$81.30

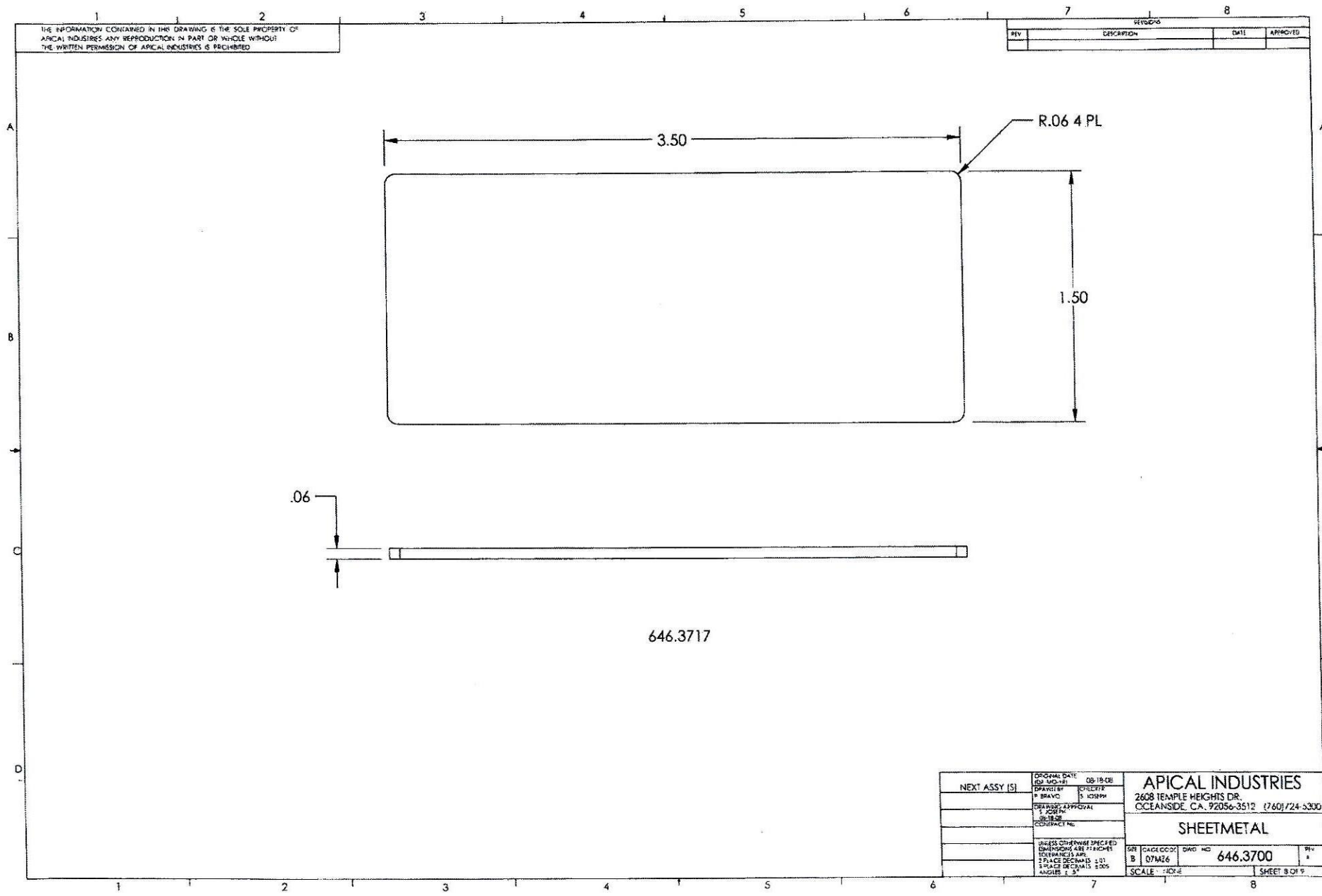
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				Items						
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	171148	RBE703A95-0520-01-1	Quill -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/16/18	6 pcs	0 pcs	6 pcs	\$13.55/pcs	\$81.30
6	170554	647.0113	Strut Doubler Issue P/O to ATG : Hard anodize, Color Black and Prime as Per Dwg 647.0100 Rev. A	Firmed	2/28/18	16 pcs	0 pcs	16 pcs	\$12.80/pcs	\$204.80
7	170470	646.3715	Strut Doubler Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	2/28/18	24 pcs	0 pcs	24 pcs	\$7.30/pcs	\$175.20
8	169913	SWA6A-700	Wire Clamp -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	2/28/18	20 pcs	0 pcs	20 pcs	\$5.10/pcs	\$102.00
9	169727	SWA10A-700	Wire Clamp : IPP Rev A 17.11.08 New issue DP Verify DD -Issue P/O to ATG: -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -Certificate of Conformity is required	Firmed	2/28/18	12 pcs	0 pcs	12 pcs	\$5.10/pcs	\$61.20
10	170474	646.3719	Doubler Issue P/O _____ ATG, balck anodize and prime as per dwg 646.3719 Rev. A	Firmed	2/28/18	24 pcs	0 pcs	24 pcs	\$7.30/pcs	\$175.20
11	168246	646.3716	Gauge Bracket Issue P/O to ATG : _____ ATG, balck anodize and prime as per dwg 646.3716 Rev. A	Firmed	2/28/18	10 pcs	0 pcs	10 pcs	\$7.20/pcs	\$72.00
12	170472	646.3717	Doubler Issue P/O _____ ATG, black anodize and prime as per dwg 646.3717 Rev. A	Firmed	2/28/18	12 pcs	0 pcs	12 pcs	\$7.30/pcs	\$87.60
13	170473	646.3718	Custom Washer Issue P/O _____ ATG, black anodize and prime as per dwg 646.3718 Rev. A	Firmed	2/28/18	30 pcs	0 pcs	30 pcs	\$5.00/pcs	\$150.00
Grand Total: \$1,331.30										
Order Notes										

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THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



NEXT ASSY (S)		ORIGINAL DATE (BY MO-YR)	08-18-08
DRAWN BY		DESIGNED BY	15-102899
P. BRAYC		DRAWN BY APPROVAL	T. JOSEPH
		DATE	08-18-08
		CONTRACT NO.	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS TO 3 PLACES FRACTIONS 1/16, 1/8, 1/4, 3/8, 1/2, 5/8, 3/4, 7/8	
SIZE	CAGE CODE	QANT NO.	REV
B	07M26	646.3700	A
SCALE: 1:1		SHEET 8 OF 9	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760) 724-5300
SHEETMETAL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914687

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577		Fax: 613 632-1000	
Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
24 ea	Part: 646.3719 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22511		Rev: A PO: PO038962 Line: 10
10 ea	Part: 646.3716 Gauge Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22512		Rev: A PO: PO038962 Line: 11
12 ea	Part: 646.3717 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22513		Rev: A PO: PO038962 Line: 12
30 ea	Part: 646.3718 Custom Washer Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22514		Rev: A PO: PO038962 Line: 13
16 ea	Part: 647.0113 Strut Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22515		Rev: A PO: PO038962 Line: 14
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914687

Date: 28-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	- .9 mils) per drawing. Job: 22507	PO: PO038962	Line: 6
24 ea	Part: 646.3715 Strut Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22508	Rev: A PO: PO038962	Line: 7
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>28/2/18</u> Certified Signature: <u><i>Diane Baker</i></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			